Work Orden March-01-13 1:5		950		*979	150*						Page 1
Item ID: [Revision ID:	D2265		_	Accept	*N900	040	100)* s	etup Start	I V	S1*
Item Name: S	Step Bracket		30,						Stop	*N,	S2*
Start Date: 3	3/01/13	Start Qty: 12.00	*19*		Cust Item 1	D:			,		
Required Date: 3 Reference:	3/08/13	Req'd Qty: 12.00	*12*		Customer:			_	S. C.		
Approvals:	Process Plan	n: MLJ	Date: 13-03-0	Ƴ Tooling:	D	ate:		ŀ	Run Start	17	R1*
			Date:		D	ate:			Stop	*N	R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr									
D2265	Rev	A									
100		PURCHASING		0.00				H	13/0	3/04	30_
Purchasing Purchasing		Memo Issue P/O: ∫ Alpine Four	9237 Cast parts per dryMaterial release note re	0.00 r drawing D2265Possible equired	Supplier						
			* 5								
*110 *110*		Receive & Inspect for Da	amage & Mat'l Certs	0.00					/1	2/3/2	1 1 (3)
Packaging Packaging		Memo Ensure Mate	erial Release Note is attach	0.00 ed					/	2J-7 = 1	
								•			
120		QC6- Inspect dimension	s to drawing	0.00				26			1
120 QC Quality Control	-	Memo		0.00 1332)			<i>30</i>		on V ter - professor	

										DQA	: Da	te:	
NCR:	Yes / No				WORK ORDER NON-	COL	NFORM	/ANCE / UPI	DATE				
										QA Closed	l: Da	te:	
Work Orde	ar:		,		DISPOSITION				AGAINST DE	PARTMEN	T/PROCESS		
WOIK OIG				<u> </u>	Rework	1		Skid-tube	Crosstube]	Water Jet		Engineering
Part N	No.				Scrap	1		Machining	Small Fab	Pr	od. Eng. Coor.	\vdash	Quality
					Use-as-is	1		noforming	Finishing	4	ore/Packaging		Other
NCR N	No.				Work Order Update	1		Large Fab	Composite	1	Supplier		
Root					ption of work order update		nitial	Act		Sign &	1 _		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verificatio	n	QC Inspector
Doc/Data											1	,	
Equip/Tooling													
Operator								i					
Material						}		I					
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Other				•		l		Í		ļ			
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Training								ł					
Unapproved										<u> </u>	<u> </u>		
						AUL	T CATE	3ORY			<u> </u>		
Landi	ng Gear				General	$\overline{}$	۱ ،]		$\overline{}$	Pressure/Forced
	Bending			_	Bend BONA (Bounts	\vdash	Grain		<u> </u>	Ovalized		-	i '
		lot Conce	ntric to	^{0/5} -	BOM/Route	_	Hardwa		 -	-	er tolerance	-	Temperature/Cure Weld
	Cracks	<i>(c</i> :)		_	Broken/Damaged	-	1	on Incomplete	landon	Part Incorr		\vdash	-1
		/Crimped	-	-	Burrs	\vdash	4	ions Incomplete/l	Unclear	Part Lost/N	_		Wrong Stock Pulled
	Cuffs	- 4		-	Contamination	\vdash	Mainte		-	Part Move			
	Heat Tre			<u> </u>	Countersink	-	Mislabe		 	Positioned	_	$\overline{}$] ₀₄₅
	Inspection	on Strip in	Tube	1	Cut Too Short		Misread	i		Power Los	s/Surge	\perp	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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Work Ord March-01-13 1		950		*979	150*							Page 2
Item ID: Revision ID: Item Name:	D2265 Step Bracket			Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	3/01/13 3/08/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*	1	Cust Item I Customer:	D:						
Approvals:		ın:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 130 *120* Small Fab	D	Operation Description Small Fab Memo		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qty	•	Reject Number	Insp. Stamp
Small Fab			castings as per Dwg D226:	0.00				7 0				
140 QC Quality Control		Memo		0.00 /3 3 3	07			<u>30</u>			· .	
150 *150*		Identify as per dwg & Sto	ock Location:	0.00					Æ	-3 -3	/3/2	27 (3

Packaging

Packaging

Memo

										DQA:	Date:	
NCR:	Yes / No				WORK ORDER NON-	COI	NFORM	/ANCE / UP	DATE	QA Closed:	Date:	.e.
· · · · · · · · · · · · · · · · · · ·							<u> </u>	····				
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap Use-as-is		ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	No				Work Order Update		ŧ	Large Fab	Composite	, Rec/3to	Supplier	
Root		[Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data								I				
Equip/Tooling								1				
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Setup												
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	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	ot Concer	ntric to C)/S	BOM/Route		Hardwa	re	<u> </u>	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Trea	at			Countersink		Mislabe	led		Positioned \	Wrong	-
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss,	/Surge	Other
{	Rinnles in	Rend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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Work Ordo		950		*979	950*					Page 3
Item ID: Revision ID: Item Name:	D2265 Step Bracket			Accept	*N900	040	100	* Se	tup Start Stop	ויאו
Start Date: Required Date: Reference:	3/01/13 3/08/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*	4.	Cust Item I Customer:	D:		·		
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):		ate:		Rı	in Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 160 *160*	D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty		Reject Insp. Number Stamp
QC Quality Control		Memo		0.00						~WF

(3-3-28

										DQA:	Date:	
NCR:	Yes / No)			WORK ORDER NON-	COI	VFORM	MANCE / UPDATE		0461	Data	4
										QA Closed:	Date:	
NAV = mls O mal					DISPOSITION			AGAINS	ST DE	PARTMENT/	PROCESS	
Work Ord	er:				Rework	1		Skid-tube Crosstub		7	Water Jet	Engineering
Dovt N	No.				 -	1	ļ ,	Machining Small Fa		Prov	d. Eng. Coor.	Quality
Part N	VO				Scrap Use-as-is	┨	l .	noforming Finishir	-	4	e/Packaging	Other
NCR I	No				Work Order Update	1		Large Fab Composit	~ }	1 1160/3101	Supplier	
NCK	1 0.				Work Order opuate	J		composi]	3466.	
Root		1		Descr	iption of work order update		Initial	Action	•	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Cr	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data											-	
Equip/Tooling												
Operator						1						
Material												
Setup												•
Other												
Process												
Supplier												
Training	Ш											
Unapproved			<u> </u>	<u> </u>								<u> </u>
						AUI	T CATE	GORY				
Landi	ng Gear			_	General		1		_	7		7_
,	Bendin	_			Bend		Grain		\vdash	Ovalized		Pressure/Forced
	⊢	Not Conce	ntric to	O/S	BOM/Route	-	Hardwa		-	Over/Under		Temperature/Cure
	Cracks			L	Broken/Damaged	<u> </u>	4	on Incomplete	_	Part Incorred	 	Weld
		d/Crimped	-	<u> </u>	Burrs	<u></u>	4	ions Incomplete/Unclear	\vdash	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	<u> </u>	Mainte	nance	<u> </u>	Part Moved		
	Heat Tr	eat			Countersink	1	Mislabe	led	- 1	Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

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Picklist Print

March-01-13 1:51:39 PM

Page 1

Work Order ID:

97950

Parent Item:

D2265

Parent Item Name:

Step Bracket

Start Date: 3/01/13

Required Date: 3/08/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP D98.12.15Added Dwg RevDM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
D2265P		Purchased	No			100	Each	0.0000	1	12				
Cton Comment Continu														

Step Support Casting

PU3/3/2, (30)

												DQA:	Dat	e:	
NCR:	Yes	/ No				WORK ORDER NON-	O	VFORN	MANCE / UP	DATE		QA Closed:	Dat	٠۵٠	,
						DICROCITION				ACAINST	•	PARTMENT/	<u> </u>		
Work Orde	er:					DISPOSITION	_			AGAINSTE		PARTIVICIVI)	PROCESS -		
Part f						Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
	•						_								
Root					Descri	ption of work order update		Initial	Ac	ction		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	1	QC Inspector
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup							ļ								
Other								-							
Process												•			
Supplier												ļ			
Training															
Unapproved															
						F	AUL	T CATE	GORY						
Landi	ng G	iear				General		-		_		•	,		,
	Ш	Bending				Bend		Grain				Ovalized			Pressure/Forced
	Ш	Centre No	ot Concer	ntric to (D/S	BOM/Route		Hardwa	re	L		Over/Under	tolerance	_	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorred	ct	_	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete,	/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance			Part Moved			
		Heat Trea	it			Countersink		Mislabe	led			Positioned V	Vrong		-
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	l	[Power Loss/	Surge		Other
		Ripples in	Bend			Drill Holes		Offset							

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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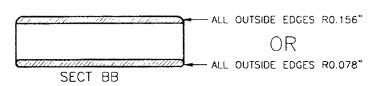


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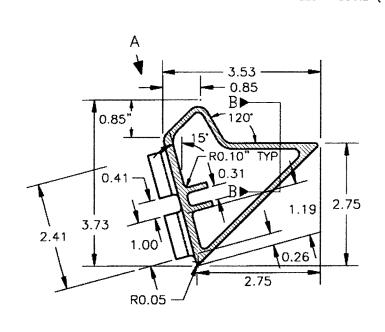
E	DAK ACKO ACCOUNTION	-
Williams	VICTORIA INTERNATIONAL AIRPORT, CANADA	
ECKED APPROVED		20
	D2265 SHEET 1	
	INTLE	ın l
ig. 18, 1994	STEP SUPPORT CASTING	

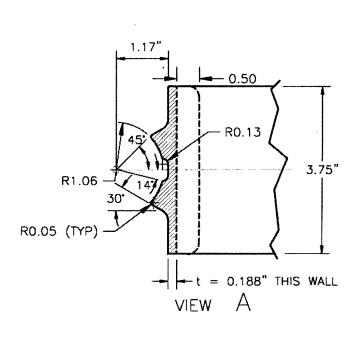


USCOMIRON FOR SERBOARD OF N. 14-185 ...

UNDIMENSIONED OUTER RADII 0.375" UNDIMENSIONED INNER RADII 0.25" UNDIMENSIONED WALL THICKNESSES 5/32"

MATERIAL: CAST ALUMINUM ALLOY A356.2 (F)





Copyright ACCESSORIES INC



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19237

Purchase Order Date 3/04/13 PO Print Date 3/04/13

Page Number 1 of 1

Order From:

VC-ALP001

ALPINE NON-FERROUS FOUNDRY 8657 - 132ND STREET

SURREY, BC V3W 4P1

CA

Contact Name

Vendor Phone

604 596 8080

Vendor Fax

604 596 8045

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607 Net 30

Terms Currency

CAD

FOB

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA



Line Nbr Reference

Revision ID

Description/ Mfg ID

Req Date/

Taxable Unit of Measure

Each

Req Qty/ Ship Method

Unit Price

Extended Price

Vendor Part Number

D2265P

Step Support Casting

3/20/13

Yes

30.00 FedEx PI collect

\$15.6500

\$469.50

Special Inst:

AS PER DWG D2265\REV. A

B97950

MATERIAL: CAST ALUMINUM ALLOY

A356.2 (F)

PO Total:

\$469.50

CERTIFICATE OF CONFORMITY REO'D UPON DELIVERY

couse acquice & and delivery. Thunks Chantal.

MATERIAL CERTIFICATION

Clavoire @ dantaero.com

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required / YES NO

Change Nbr:

Change Date: 3/04/13

ALPINE NON-FERROUS FOUNDRY

8657-132ND STREET SURREY, B.C. V3W 4P1 WORK ORDER PACKING LIST

Tel: (604) 596-8080 Fax: (604) 596-8045

Sold To:

Comments

Castings&Patterns are property of Alpine until paid in full

DART AEROSPACE

1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7

CANADA

Ship To: DART AEROSPACE

	Order		Purchase Order#	Due Date			p Via		Page
Item#	04-Ma	da a sa mata 🙈 asa i	PO19237 Description	20-Mar-13	Material	FE Ordered	DEX B/O	Qty Ready	1 Qty Ship
1	DART [D2265 CSTG,SUPPORT B	RACKET	356,2	30	ВЮ	Lary Ready:	30
		:							
	·		;					·	
			;						
	,								



G3C: NAPM-ALUMAX OF SC CASTHOUSE-INV Alumax of South Carolina Inc 3575 Highway 52 Goose Creek, SC 29445

Producer: Alcoa Inc Brand: MT HOLLY

Invoice To Customer
VISTA SALES INC
8157 LANKERSHIM BLVD
LOS ANGELES, CA - 91605

Ship To Customer
VISTA SALES INC
C/O RYPAC ALUMINUM RECYCLING LTD
11849 TANNERY ROAD
SURREY, BC - V3V3W8

Certified Inspection Report

				Cert Number NAPM2505153	Page 1/I
Sales Order Nun	ıber		Customer P/O		Cert Print Date
	Line				
1000392349	No.	1	2012-0657	07-JUN-12	07-JUN-12

PS

Item Description

ALUMINUMINGOT|STANDARD|A356.2S|C625|HDC-35|

Quantity Shipp	ped	Date Shipped	
44965	LB	07-JUN-12	
B/L		Item No.	
2011994		G3E142099	
Delivery ID		Item No. Rev	·
7062264			
Customer Part	No		

G3E142099

Signature And Title

Legal Statement

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product. This certification is not to be reproduced in partial form without prior written approval of our Quality Assurance Dept.

Dee Davidson Technical Manager

07-JUN-12

Quantities per Lot / Packages

	Package Number	Lot Number	Sub Lot / Serial Number	Quantity	UOM	Weight		
L		2001. Gillioti				Gross	Net	
L	j j	204F91006	C6250736	12486	LB	12486	12486	
L	1	205F91802	C6250728	5000	LB	5000	5000	
1	1	206F90901	C6250738	14990	LB	14990	14990	
	1	206F90902	C6250739	12489	IR	12480	12480	

Composition Results

Heat / Cast / Lot Number	Si	Fe	Cu	Mn	Mg	Zn	Ti	Ca	Ga	Na	Sr	V
02-JUN-2012/C6250 738	7.2	0.11	<0.01	<0.01	0.39	<0.01	0.11	<0.001	0.01	0.001	0.027	0.01
03-JUN-2012/C6250 739	7.2	0.10	<0.01	<0.01	0.40	<0.01	0.12	<0.001	0.01	0.002	0.029	
11-MAY-2012/C625 0728	7.0	0.11	<0.01	<0.01	0.37	<0.01	0.13	0.001	0.01	0.002	0.028	0.01
21-MAY-2012/C625 0736	7.1	0.11	<0.01	<0.01	0.40	<0.01	0.13	0.001	0.01	0.001	0.028	0.01